

Date: Monday, 7/30/2007 1:54:17 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE	
Job Number	33802				
Estimate Number	12786				
P.O. Number	N/A		Part Number	D35645	
This Issue	7/30/2007	S.O. No.	N/A	Drawing Number	D3564 REV C
Prsht Rev.	NC		Project Number	N/A	
First Issue	N/A		Drawing Revision	C	
Previous Run	32738		Material	N/A	
Written By			Due Date	8/28/2007	
Checked & Approved By			Qty:	12	
Comment			Um:	Each	
Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 1.1099 sf(s)/Unit Total : 13.3182 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M 105 061</u> <u>B 07-07-31</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: <u>C</u> <u>B 07-07-31</u> Prog Rev: <u>C</u>		
2-Deburr if necessary <u>07/08/07</u> <u>km(12)</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 07-07-31</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>E 07/07/31 X12</u>		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT Form Joggle as per Dwg D3564 on brake using Jig DT <u>FF 07-08-08</u> <u>12</u> <u>FF 07-08-08</u> <u>12</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						=	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/18/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:54:17 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 33802

Part Number: D35645

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Counted

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/08/09

(12)

7.0 POWDER COATING POWDER COATING



M104846

(2x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-A 07/08/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-14.

BK

07-08-10

(12)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/10

Job Completion



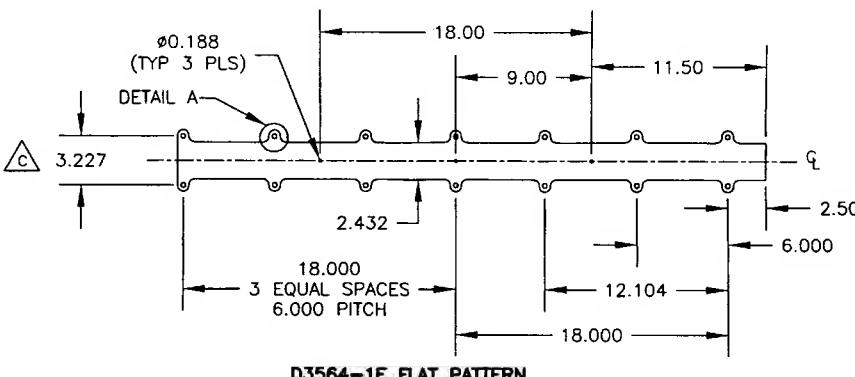
C 20/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

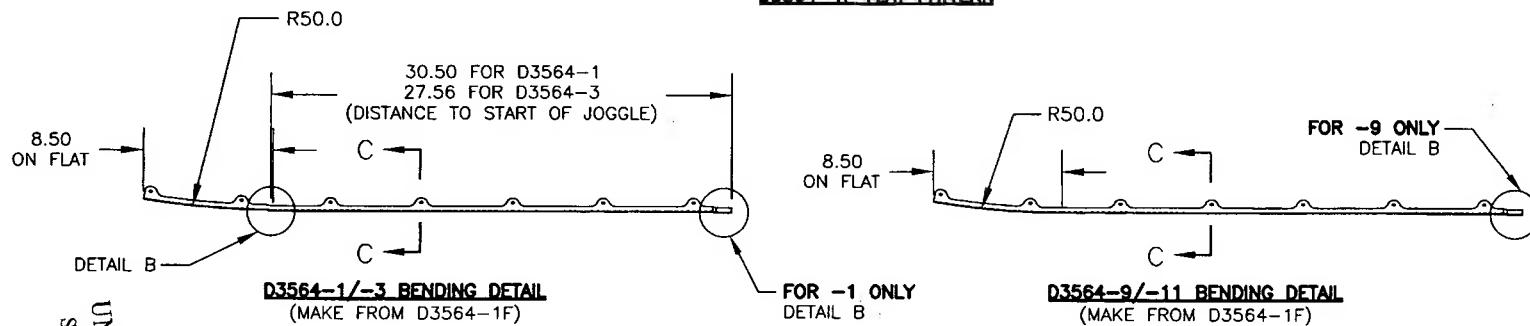
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

D3564-1/-3/-9/-11 WELDING DETAIL

NO. 33802
WORK ORDER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

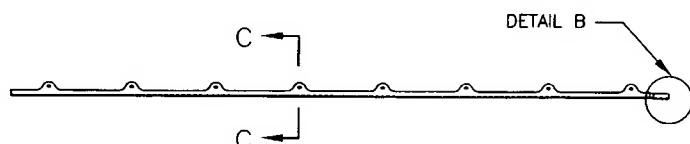
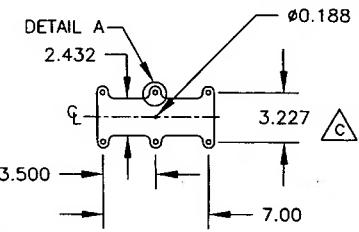
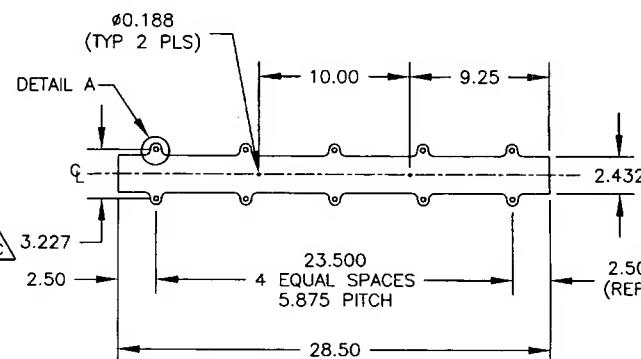
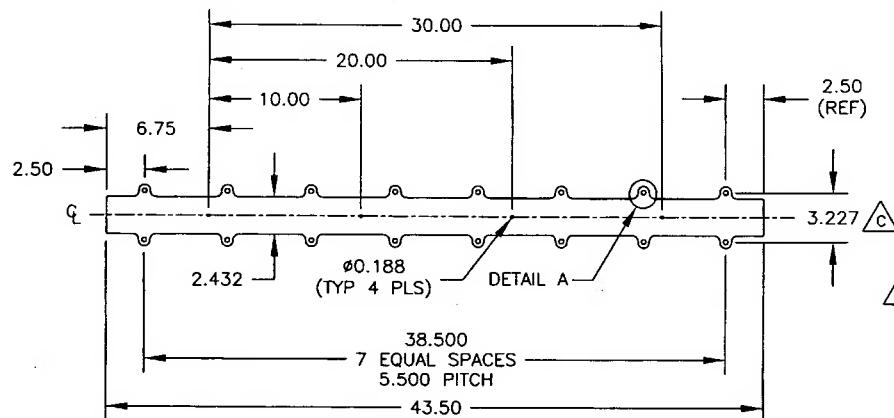
D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

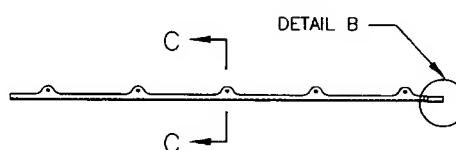
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART
PJL	PH	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D3564
DATE	TITLE	REV. C
07.04.17	WEARSHOE	SHEET 1 OF 2
		SCALE
		1:8

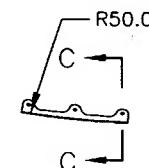
RELEASED
07.06.28



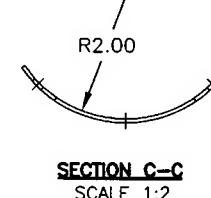
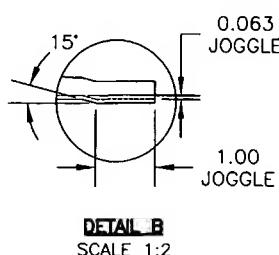
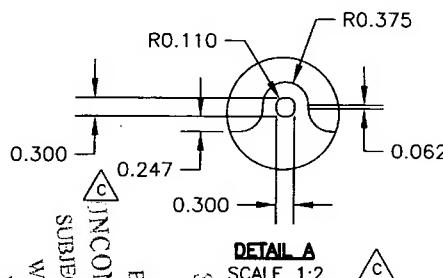
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



NO. 33802
WORK ORDER
RETURN TO
ENGINEERING
WITHOUT NOTICE
SUBJECT TO AMENDMENT
INCONTROLLED COPY

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
#	P4		REV. C
#	#	D3564	SHEET 2 OF 2
DATE	TITLE		SCALE
07.04.17	WEARSHOE		1:8

RELEASED
07.06.2011

DART AEROSPACE LTD	Work Order:	33803
Description: WEAR SHOE	Part Number:	D 3564-15
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>EN</u>	Prototype Approval: <u>N/A</u>
Date: <u>07-07-31</u>	Date: <u>07/07/31</u>	Date: <u></u>

Rev	Date	Change	Revised by	Approved
X		New Issue	KJ/JLM	